

# Work Order ID 81489

March-14-12 4:22:01 PM

**\*81489\***

Page 1

Item ID: D3642-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 14/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/14

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3642	Rev B								

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3642 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

B12-3-20

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B12-3-20

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

12-3-20

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*81489\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 14/03/2012    **Start Qty:** 12.00    **\*12\***

**Cust Item ID:**

**Required Date:** 23/03/2012      **Req'd Qty:** 12.00      **\*12\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

130 Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

## Memo

0.00

## Hand Finishing

140 QC3- Inspect Part Finish

0.00

**\*140\***

OC

## Memo

0.00

## Quality Control

150 Identify as per dwg & Stock Location: ST 244 0.00

0.00

**\*150\***

### Packaging

## Memo

0.00

## Packaging

⑫ NG-12-3-21

12 X ~~0~~ 12/03/21.

12x 87 12-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81489

**\*81489\***

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March-14-12 4:22:01 PM

Item ID: D3642-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 14/03/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 23/03/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/3/21  
 MF  
 12-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 4:22:04 PM

Page 1

Work Order ID: 81489

\*81489\*

Parent Item: D3642-1

\*D3642-1\*

Parent Item Name: Doubler

Start Date: 14/03/2012

Required Date: 23/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	33.9000	0.1664	2.101895			

\*M2024T3S 050\*

2024-T3 .050 sheet

\*\*

1812-3-20

Location

Loc Qty

Loc Code

MAT022

33.9

117684

33.9

117684

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81489
<b>Description:</b> Doubler		<b>Part Number:</b>	D3642-1
<b>Inspection Dwg:</b> D3642	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	0.127	2		V B62	
Ø0.098	+0.004/-0.001	0.099	2		V	
0.35	+/-0.030	0.348	2		V	
1.25	+/-0.030	1.254	2		V	
1.700	+/-0.010	1.699	2		V	
2.15	+/-0.030	2.154	2		V	
3.05	+/-0.030	3.053	2		V	
3.95	+/-0.030	3.950	2		V	
4.078	+/-0.010	4.078	2		V	
4.85	+/-0.030	4.847	2		V	
5.20	+/-0.030	5.203	2		V	
0.343	+/-0.010	0.340	2		V	
0.40	+/-0.030	0.401	2		V	
1.30	+/-0.030	1.310	2		V	
3.35	+/-0.030	3.353	2		V	
3.47	+/-0.030	3.468	2		V	
3.79	+/-0.030	3.79	2		V	
3.959	+/-0.010	3.959	2		V	
4.08	+/-0.030	4.077	2		V	
4.60	+/-0.030	4.606	2		V	
1.537	+/-0.010	1.538	2		V	
3.28	+/-0.030	3.286	2		V	
3.80	+/-0.030	3.80	2		V	
3.915	+/-0.010	3.917	2		V	
0.450	+/-0.010	0.451	2		V	
4.066	+/-0.010	4.064	2		V	
4.20	+/-0.030	4.197	2		V	

<b>Measured by:</b> B	<b>Audited by:</b> SA	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-3-20	<b>Date:</b> 12/3/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	

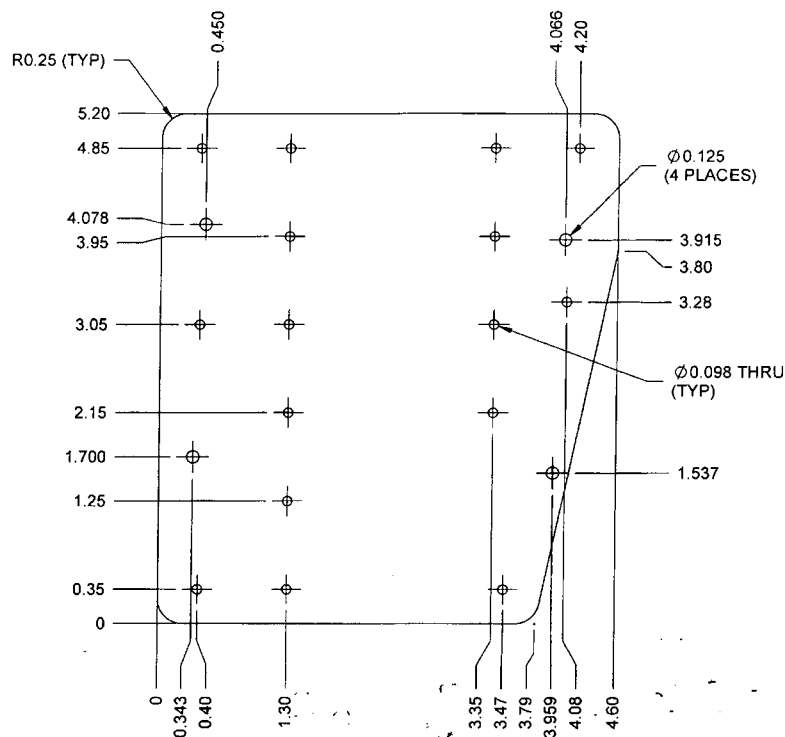
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)** B

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. B1489 MLJ  
12/03/14

RELEASED  
07.11.14

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S 050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	07.10.16		

<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWING NO. <b>D3642</b>	REV. B
TITLE <b>DOUBLER</b>	SHEET 1 OF 1 SCALE 4:5
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries